

**Work Order ID 68600**

Monday, April 18, 2011 12:30:00 PM



Page 1

Item ID: D3245-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 4/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                          | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr                                                                                                      |                      |         |        |              |               |               |                  |                |
| D3245                          | Rev B                                                                                                             |                      |         |        |              |               |               |                  |                |
| 100                            | Pick Kit                                                                                                          | 0.00                 |         |        |              |               |               |                  |                |
|                                | Packaging                                                                                                         | 0.00                 |         |        |              |               |               |                  |                |
|                                | Packaging                                                                                                         |                      |         |        |              |               |               |                  |                |
| 110                            | Small Fab                                                                                                         | 0.00                 |         |        |              |               |               |                  |                |
|                                | Small Fab                                                                                                         | 0.00                 |         |        |              |               |               |                  |                |
|                                | Small Fab                                                                                                         |                      |         |        |              |               |               |                  |                |
|                                | Memo                                                                                                              |                      |         |        |              |               |               |                  |                |
|                                | Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245 be careful when countersinking...mat'l very thin |                      |         |        |              |               |               |                  |                |
| 120                            | QC5- Inspect part completeness to step on W/O                                                                     | 0.00                 |         |        |              |               |               |                  |                |
|                                | QC                                                                                                                | 0.00                 |         |        |              |               |               |                  |                |
|                                | Quality Control                                                                                                   |                      |         |        |              |               |               |                  |                |

5/4/04/19 (6)

11/04/27 (6)

8/4/04/27

 (6)  
242

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 68600**

Page 2

Monday, April 18, 2011 12:30:00 PM

Item ID: D3245-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 4/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location

233A

0.00



Packaging

Memo

0.00

Packaging

11/4/28 SL 100

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28 JF  
ME

11-04-28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 18, 2011 12:30:07 PM

Page 1

Work Order ID: 68600

Parent Item: D3245-042

Parent Item Name: Access Panel Assembly





Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

| Component Item ID/<br>Item Name                                                                                      | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit     | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|----------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| 2350-18-C3Y<br><br>RIGID RECEPTACLE |                        | Purchased     | No          |                     |                  | 110             | Each               | 146.0000       | 8               | 48           |               |                |        |
|                                                                                                                      |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                                                                                      |                        |               |             | ST399               |                  |                 | 46                 |                |                 |              |               |                |        |
|                                                                                                                      |                        |               |             | 105729              |                  |                 | 2                  |                |                 |              |               |                |        |
|                                                                                                                      |                        |               |             | 117204              |                  |                 | 24                 |                |                 |              |               |                |        |
|                                                                                                                      |                        |               |             | 19688               |                  |                 | 20                 |                |                 |              |               |                |        |
|                                                                                                                      |                        |               |             | ST400               |                  |                 | 100                |                |                 |              |               |                |        |
|                                                                                                                      |                        |               |             | 117358              |                  |                 | 100                |                |                 |              |               |                |        |
| D3245-2<br><br>Panel                |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1               | 6            |               |                |        |
|                                                                                                                      |                        |               |             |                     |                  |                 | B67549 (GX)        |                |                 |              |               |                |        |
| D3245-5<br><br>Door               |                        | Manufactured  | No          |                     |                  | 110             | Each               | 5.0000         | 1               | 6            |               |                |        |
|                                                                                                                      |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                                                                                      |                        |               |             | GA                  |                  |                 | 5                  |                |                 |              |               |                |        |
|                                                                                                                      |                        |               |             | 47610               |                  |                 | 5                  |                |                 |              |               |                |        |
| MS20427M3-3<br><br>Rivet          |                        | Purchased     | No          |                     |                  | 110             | Each               | 1,638.000      | 16              | 96           |               |                |        |
|                                                                                                                      |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                                                                                      |                        |               |             | ST318               |                  |                 | 1638               |                |                 |              |               |                |        |
|                                                                                                                      |                        |               |             | 117206              |                  |                 | 1638               |                |                 |              |               |                |        |

*EP 11/04/19*

*EP 11/04/19*

*EP 11/04/27*

*B68628 (GX)*

*EP 11/04/19*

*96*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Monday, April 18, 2011 12:30:07 PM

Work Order ID: 68600



Parent Item: D3245-042



Parent Item Name: Access Panel Assembly

Start Date: 4/18/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

MS20615M3-3

Purchased

No

110

Each

200.0000

9

54



Rivet



*Signature*  
4/18/11

Location

Loc Qty

Loc Code

ST323

200

111650

100

116188

100

20  
34

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

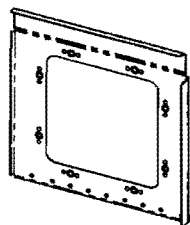
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

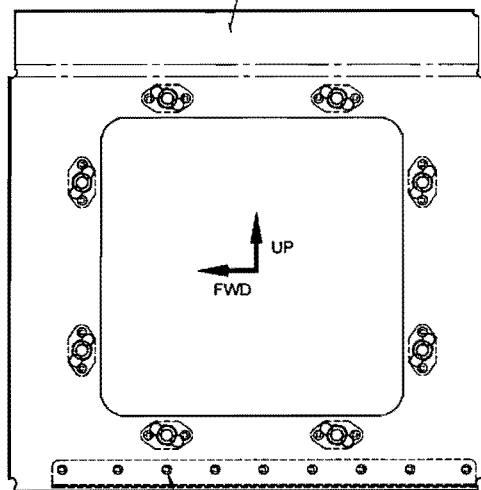
**NOTE:** Date & initial all entries





D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-041 ACCESS PANEL ASSEMBLY**

**RELEASED**  
07.10.23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68600  
*11-09-18*

D3245-5  
ANGLE PLATE

0.032  
GAP

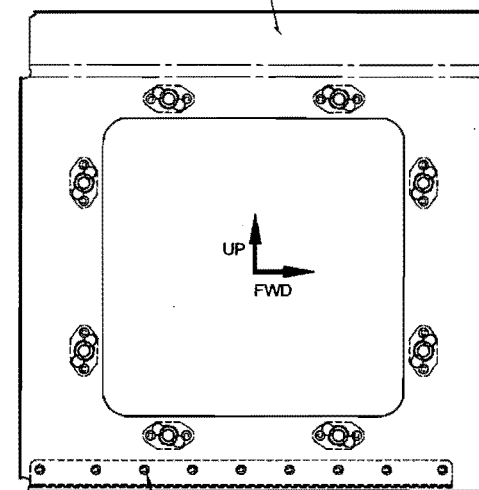
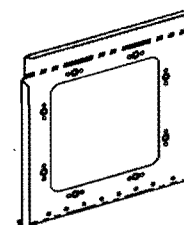
D3245-5  
ANGLE PLATE

0.032  
GAP

| QTY<br>-041 | QTY<br>-042 | P/N         | DESCRIPTION               |
|-------------|-------------|-------------|---------------------------|
| X           |             | D3245-041   | ACCESS PANEL ASSEMBLY, LH |
|             | X           | D3245-042   | ACCESS PANEL ASSEMBLY, RH |
| 1           |             | D3245-1     | PANEL                     |
| 1           | 1           | D3245-2     | PANEL                     |
| 1           | 1           | D3245-5     | ANGLE PLATE               |
| 8           | 8           | 2350-18-C3Y | DZUS RIGID RECEPTACLE     |
| 16          | 16          | MS20427M3-3 | RIVET                     |
| 9           | 9           | MS20615M3-3 | RIVET                     |

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

|            |                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                |              |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| B          | REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING | MB                                                                                                                                                                                                                                                             | 07.10.02     |
| A          | NEW ISSUE                                                                                                                                                                                               | RF                                                                                                                                                                                                                                                             | 04.01.27     |
| REV.       | DESCRIPTION                                                                                                                                                                                             | BY                                                                                                                                                                                                                                                             | DATE         |
| DESIGN     |                                                                                                                                                                                                         | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                       |              |
| DRAWN      |                                                                                                                                                                                                         | DRAWING NO.                                                                                                                                                                                                                                                    | REV. B       |
| CHECKED    |                                                                                                                                                                                                         | D3245                                                                                                                                                                                                                                                          | SHEET 1 OF 7 |
| MFG. APPR. |                                                                                                                                                                                                         | TITLE                                                                                                                                                                                                                                                          | SCALE        |
| APPROVED   |                                                                                                                                                                                                         | ACCESS PANEL ASSEMBLY                                                                                                                                                                                                                                          | 1:2.5        |
| DE APPR.   |                                                                                                                                                                                                         | COPYRIGHT © 2004 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |
| DATE       | 07.10.02                                                                                                                                                                                                |                                                                                                                                                                                                                                                                |              |

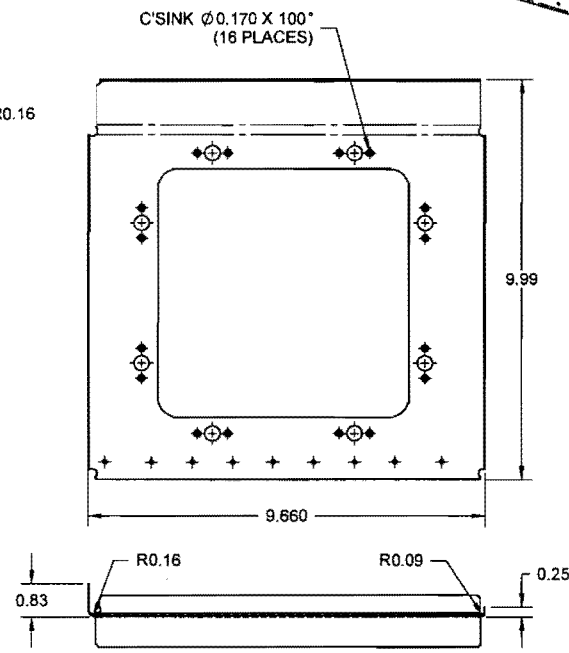
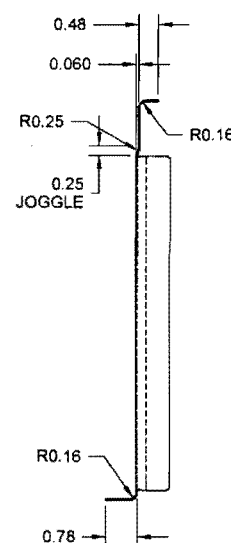
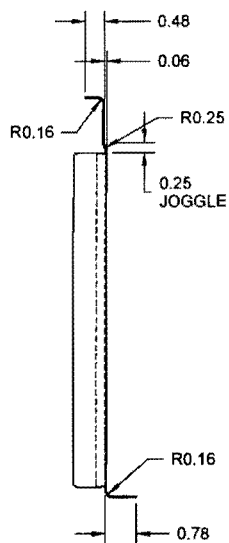
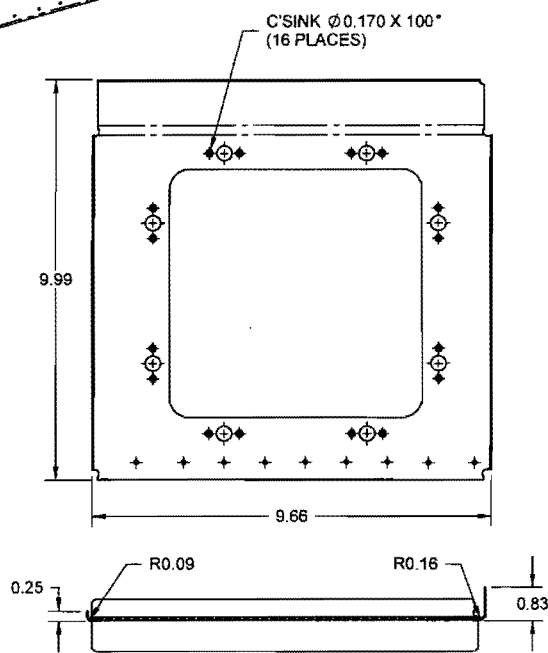
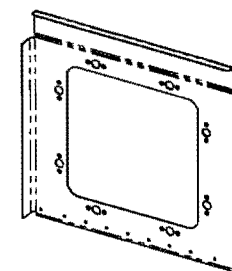
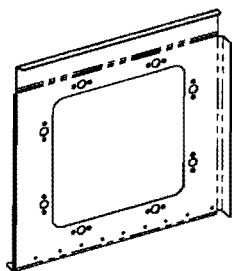
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D3245-1 PANEL BEND DETAIL, LH**

**D3245-2 PANEL BEND DETAIL, RH**

**RELEASED**  
WP 87-10-23

- NOTES:  
 1) MATERIAL: MAKE FROM D3245-1F  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.70 lbs

*w/o 68600*

|                                                                                                                                                                                                                      |                 |                                        |              |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                               | <del>TH</del>   | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                | <del>B</del>    | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                              | <del>PH</del>   | DRAWING NO.                            | REV. B       |
| MFG. APPR.                                                                                                                                                                                                           | <del>DS</del>   | <b>D3245</b>                           | SHEET 2 OF 7 |
| APPROVED                                                                                                                                                                                                             | <del>NO</del>   | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                             | <del>TH</del>   | <b>ACCESS PANEL ASSEMBLY</b>           | 1:3          |
| DATE                                                                                                                                                                                                                 | <b>07.10.02</b> | COPYRIGHT © 2004 BY DART AEROSPACE LTD |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

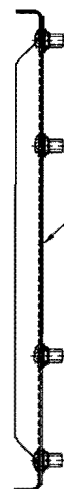
D3245-5 DOOR

2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)

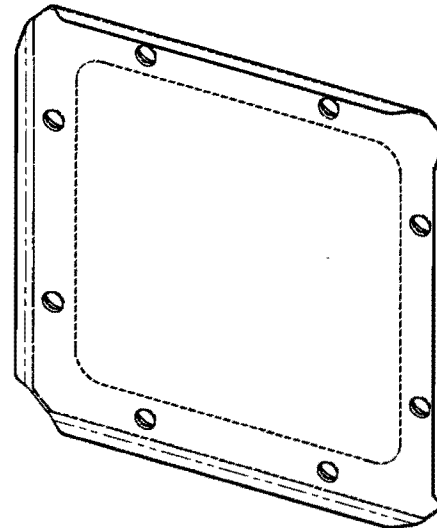
D3245-7 GASKET  
(REF)

8.00  
(TYP, REF)

**D3245-043 DOOR ASSEMBLY**



INSTALL D3245-7  
GASKET ON THIS SIDE



*w/o 68600*

| QTY<br>-043 | P/N             | DESCRIPTION           |
|-------------|-----------------|-----------------------|
| X           | D3245-043       | ACCESS PANEL ASSEMBLY |
| 1           | D3245-3         | DOOR                  |
| 1           | D3245-7         | GASKET                |
| 8           | 2351-20-009-C3Y | STUD                  |
| 8           | 127H-35         | GROMMET               |

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

**RELEASED**  
[Stamp]

|            |                    |                                                                                                                                                                                                                                                                    |              |
|------------|--------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | <i>[Signature]</i> | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                          |              |
| DRAWN      | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                        |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                        | REV. B       |
| MFG. APPR. | <i>[Signature]</i> | <b>D3245</b>                                                                                                                                                                                                                                                       | SHEET 3 OF 7 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                              | SCALE        |
| DE APPR.   | <i>[Signature]</i> | <b>ACCESS PANEL ASSEMBLY</b>                                                                                                                                                                                                                                       | 1:2          |
| DATE       | <b>07.10.02</b>    | COPYRIGHT © 2004 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8 7 6 5 4 3 2 1

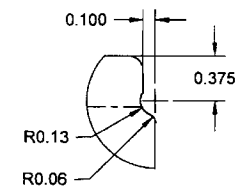
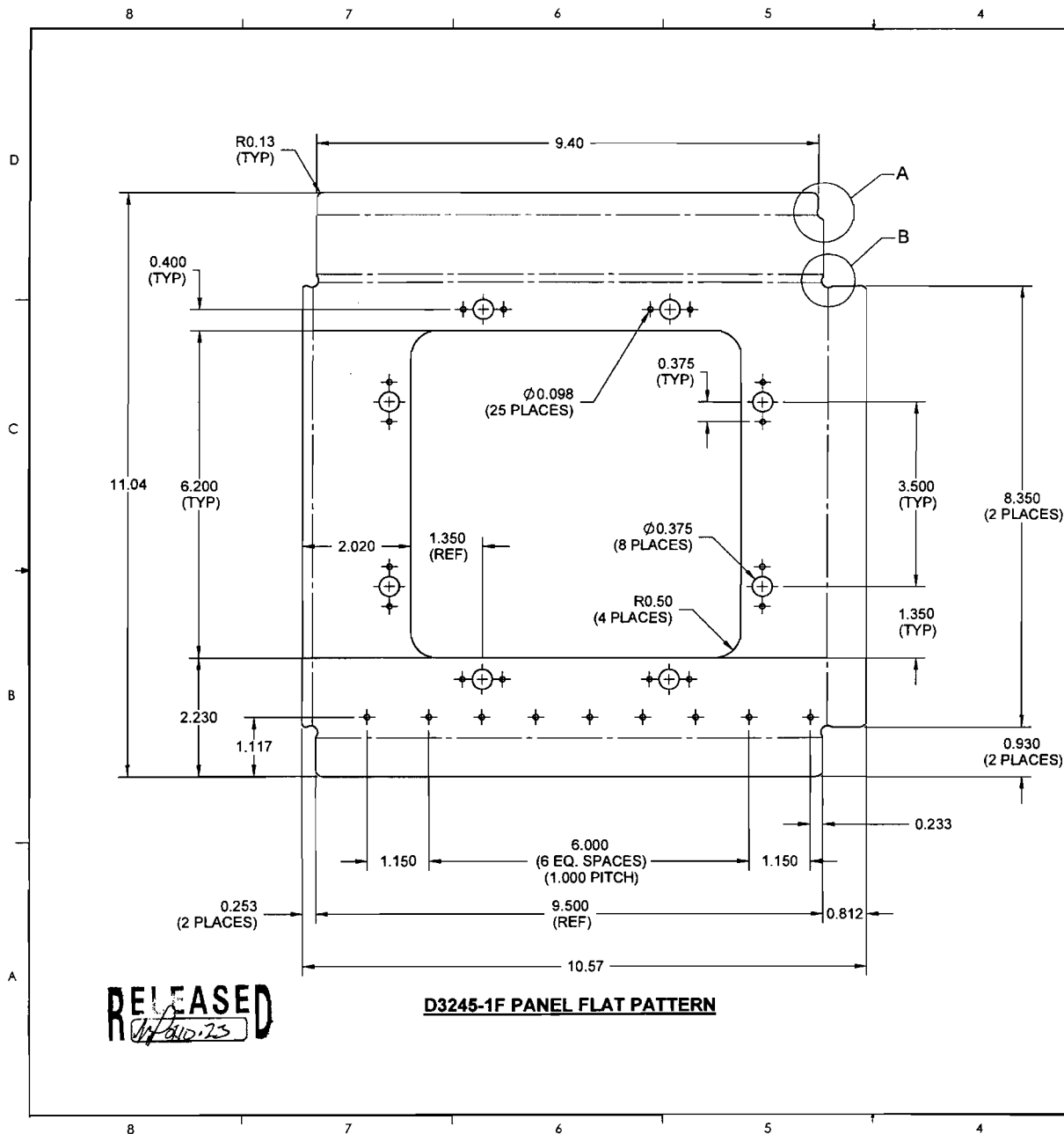
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

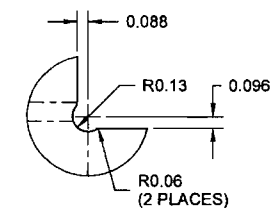
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries









**DETAIL A: RELIEF**  
SCALE 1: 1



**DETAIL B: RELIEF**  
(TYP, 4 PLACES)  
SCALE 1: 1

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET  
(0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

|                                                                                                                                                                                                                                |                                                                                       |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                         |  | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          |  | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        |  | DRAWING NO.                            | REV. B       |
| MFG. APPR.                                                                                                                                                                                                                     |  | D3245                                  | SHEET 4 OF 7 |
| APPROVED                                                                                                                                                                                                                       |  | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       |  | ACCESS PANEL ASSEMBLY                  | 1:2          |
| DATE                                                                                                                                                                                                                           | 07.10.02                                                                              | COPYRIGHT © 2004 BY DART AEROSPACE LTD |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

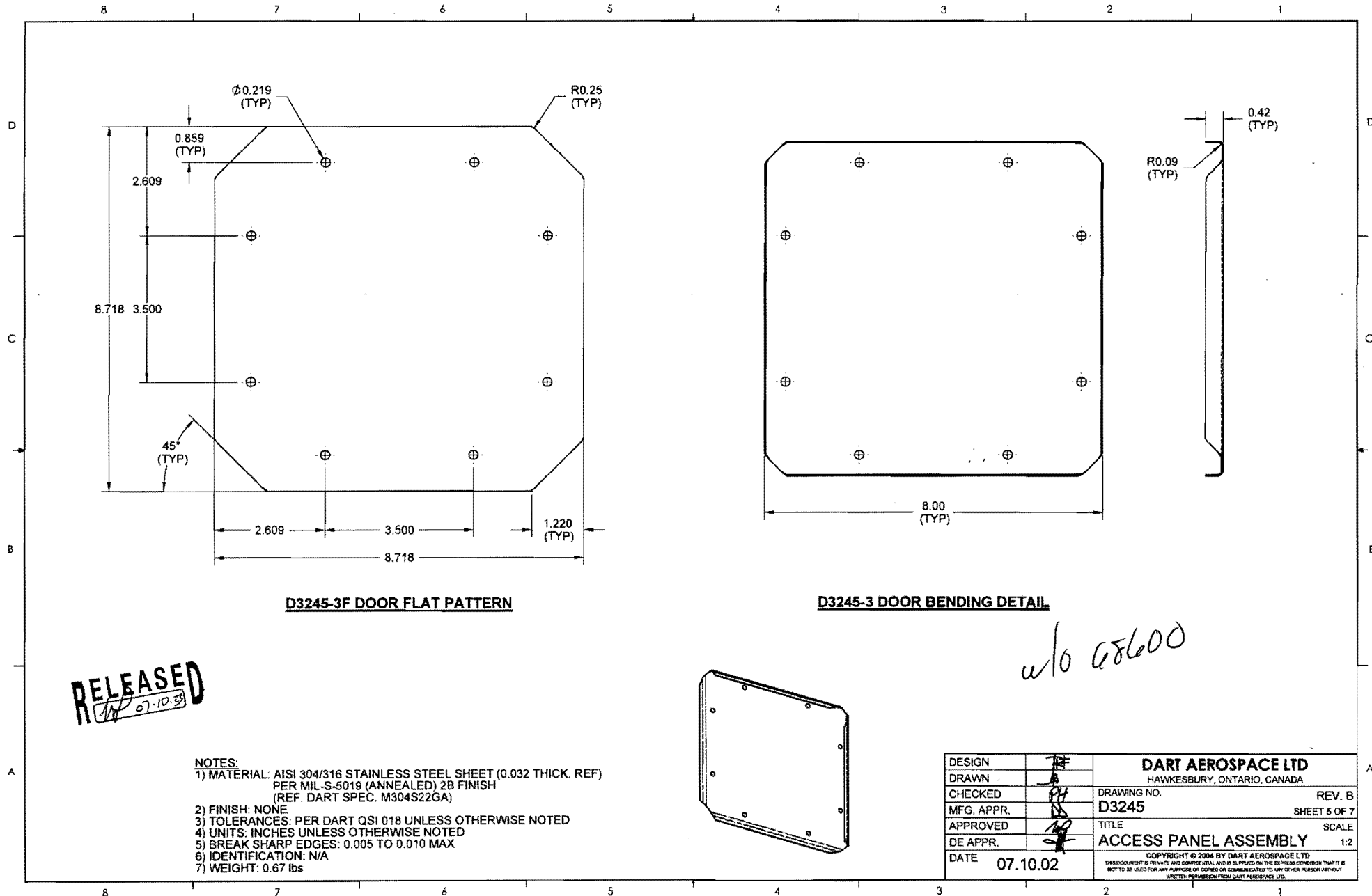
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





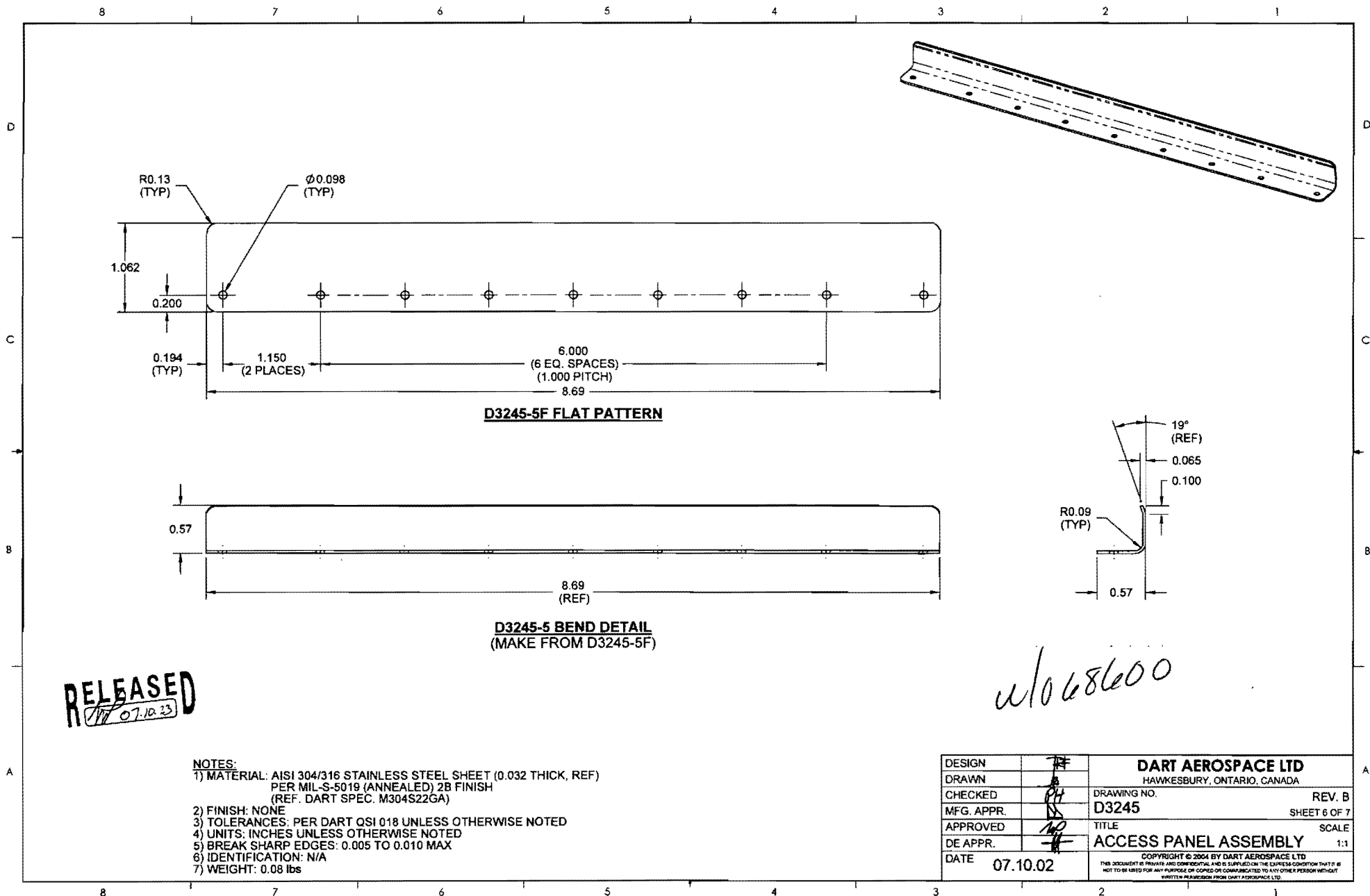
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

|                                                                                                                                                                                                                                |               |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                         | <del>7F</del> | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | <del>PH</del> | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | <del>PH</del> | DRAWING NO.                            | REV. B       |
| MFG. APPR.                                                                                                                                                                                                                     | <del>PH</del> | <b>D3245</b>                           | SHEET 6 OF 7 |
| APPROVED                                                                                                                                                                                                                       | <del>PH</del> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | <del>PH</del> | <b>ACCESS PANEL ASSEMBLY</b>           | 1:1          |
| DATE                                                                                                                                                                                                                           | 07.10.02      | COPYRIGHT © 2004 BY DART AEROSPACE LTD |              |
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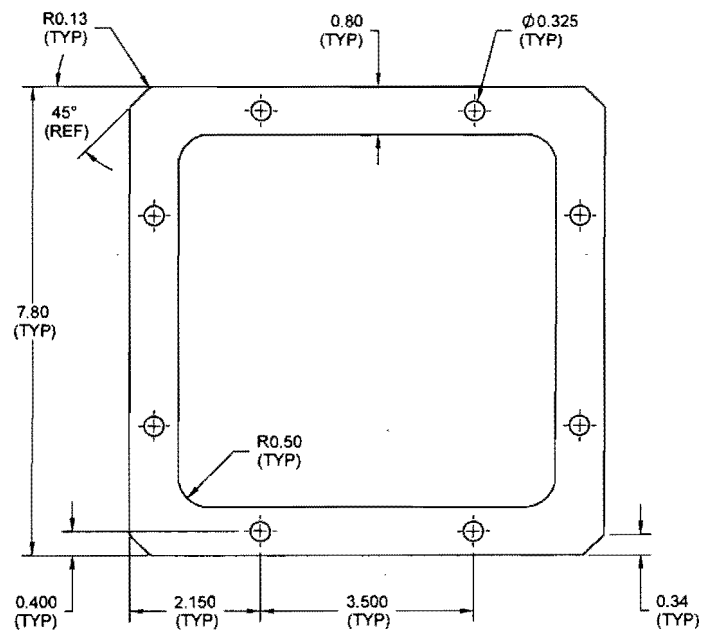
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

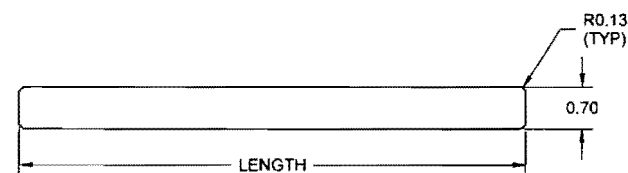
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D3245-7 GASKET**



**D3245-X GASKET**

| P/N      | LENGTH |
|----------|--------|
| D3245-9  | 8.35   |
| D3245-11 | 9.01   |
| D3245-13 | 9.50   |

**RELEASED**  
07.10.02

- NOTES:  
 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
 (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: N/A

|            |                    |                                                                                                                                                                                                                                                                                                                             |              |
|------------|--------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | <i>[Signature]</i> | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                                                   |              |
| DRAWN      | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                                                 |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                                                                 | REV. B       |
| MFG. APPR. | <i>[Signature]</i> | D3245                                                                                                                                                                                                                                                                                                                       | SHEET 7 OF 7 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                                                       | SCALE        |
| DE APPR.   | <i>[Signature]</i> | ACCESS PANEL ASSEMBLY                                                                                                                                                                                                                                                                                                       | 1:2          |
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*W/O 68600*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries